

# Work Order ID 51403

August 21, 2009 9:25:04 AM

Page 1

Item ID: D212-722-011

Accept

Revision ID: C

Item Name: Avionics Console

Start Date: 8/21/09 Start Qty: 4.00

Required Date: 9/07/09 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *CL*

Date: *09/02/09* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3363	Rev C
-------	-------

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

*Handwritten signature* BG 09/11/09

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg  
D3360 Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall  
2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel  
3/4" x 3/4" x 0.125" wall 13-Debur D3360-1/-

*Handwritten signature* 09/10/28 (4)

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

*Handwritten signature* 09-10-28

POSITIVE RECALL

EFFECTIVE 9/10/27

AUTH

*Handwritten signature* 12/1/09

BASED

DATE

*Handwritten signature* 9/12/28

*Handwritten signature* 09/11/09 (4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 51403**

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August 21, 2009 9:25:04 AM

Item ID: D212-722-011

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Setup Start



Revision ID: C

Stop



Item Name: Avionics Console

Start Date: 8/21/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/07/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	<i>ll</i>	<i>09/10/28</i>		<i>(L)</i>	<i>Ø</i>		
140  Small Fab Small Fab	Small Fab  Memo 1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail ***Mount Dzus Rails to DT8957 (Radio) and transfer drill into console. ****2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363 Identify as D3363-041	0.00 0.00							<i>EB09/11/04 (4)</i>
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	<i>2&gt; Sorlu/06</i>			<i>(L)</i>	<i>Ø</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 51403**

Page 3

August 21, 2009 9:25:04 AM

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Revision ID: C

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Item Name: Avionics Console

Start Date: 8/21/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/07/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging Packaging	Pick Kit  Memo	0.00 0.00							
170  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00							
180  Packaging Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D212-722-011	0.00 0.00							

9/09/10/28 (4)

8/29/10/09

4 0

Rev D

9/10/09 (422)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 51403**

Page 4

August 21, 2009 9:25:04 AM

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Start Date: 8/21/09 Start Qty: 4.00



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Required Date: 9/07/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/10  
mf  
09-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

August 21, 2009 9:25:04 AM

Page 1

Work Order ID: 51403

Parent Item: D212-722-011RevC

Parent Item Name: Avionics Console

Comments:

Start Date: 8/21/09

Required Date: 9/07/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

PFSC35-38A

Dzus 1/4 turn fastener

Purchased

No

100

Each

48.0000

32.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

111779

48

M6063T5A0.750W.063

Purchased

No

110

f

37.8400

29.0526

Angle6063T5 .750 X.750 X.063w

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

37.84

111018

21.85

112040

15.99

M6063T5C.75X.75W.1

Purchased

No

110

f

25.2200

3.3160

25

6063 CHANNEL.750 X.750 X.125w

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

25.22

107435

9.22

112040

16

*9/09/10/28*  
*M111779 54*  
*9/11/9*

*9/09/10/28*  
*M107983 (12)*  
*M113006*

*9/09/10/28*

*674*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

August 21, 2009 9:25:04 AM

Work Order ID: 51403

Parent Item: D212-722-011RevC

Parent Item Name: Avionics Console



Comments:

Start Date: 8/21/09

Required Date: 9/07/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3363-1RevC		Manufactured	No			140	Each	5.0000	4.0000			
												
Console												

*EP 09/10/28*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

37215

1

Main Warehouse

ST185A

4

48243

4

*4*

MS20426AD4-5

Purchased

No

140

Each

7,938.000

176.0000



Rivet

*EP 09/10/02*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7938

4067

1121

6733

1835

6874

4982

*B176*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

August 21, 2009 9:25:04 AM

Work Order ID: 51403

Parent Item: D212-722-011RevC

Parent Item Name: Avionics Console



Comments:

Start Date: 8/21/09

Required Date: 9/07/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PR3541  DZUS FASTENER RAIL		Purchased	No			140	f	7.5900	1.3332 		8/21/09	

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      7.59

107913                      7.17

17763                      0.42

MS20426AD4-6                      Purchased                      No                      170                      Each                      4,178.000                      36.0000



Rivet

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      4178

100151                      27

103395                      14

105144                      336

110139                      3774

2525                      27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

**DART AEROSPACE LTD**  
HAMKESBURY, ONTARIO, CANADA

REV. C

SHEET 1 OF 3

SCALE

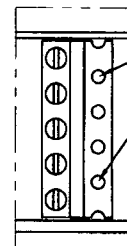
DESIGN	DRAWN BY	DRAWING NO.	TITLE	DATE
P41	P41	D3363	CONSOLE ASSEMBLY	07.01.26
CHECKED	APPROVED			
A	04.11.29	NEW ISSUE		
B	05.03.28			
C	07.01.26			

DATE	DESCRIPTION
07.01.26	INCREASE WIDTH BY 0.125
07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT

**RELEASED**

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (Ø0.225 X 100") FROM TOP SIDE OF CONSOLE



**DETAIL C**  
(SCALE 1:2)

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *51403 CL*

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (Ø0.225 X 100") FROM CONSOLE TOP SIDE

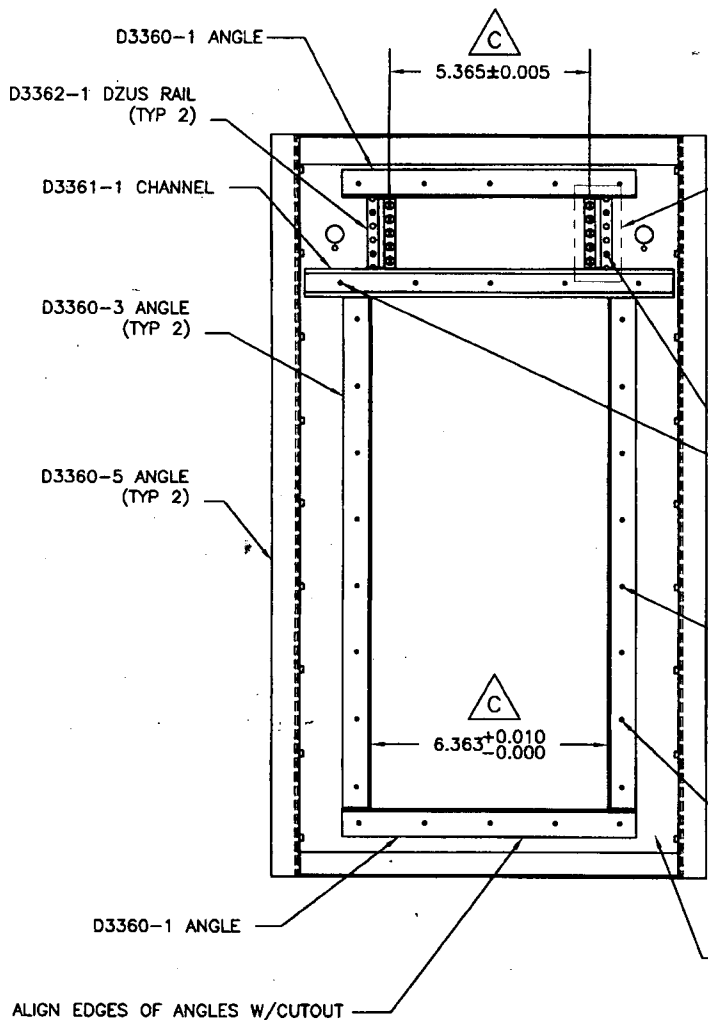
INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

**PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY**

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

**VIEW A-A FROM UNDER CONSOLE ASSEMBLY**



**D3363-041 CONSOLE ASSEMBLY**

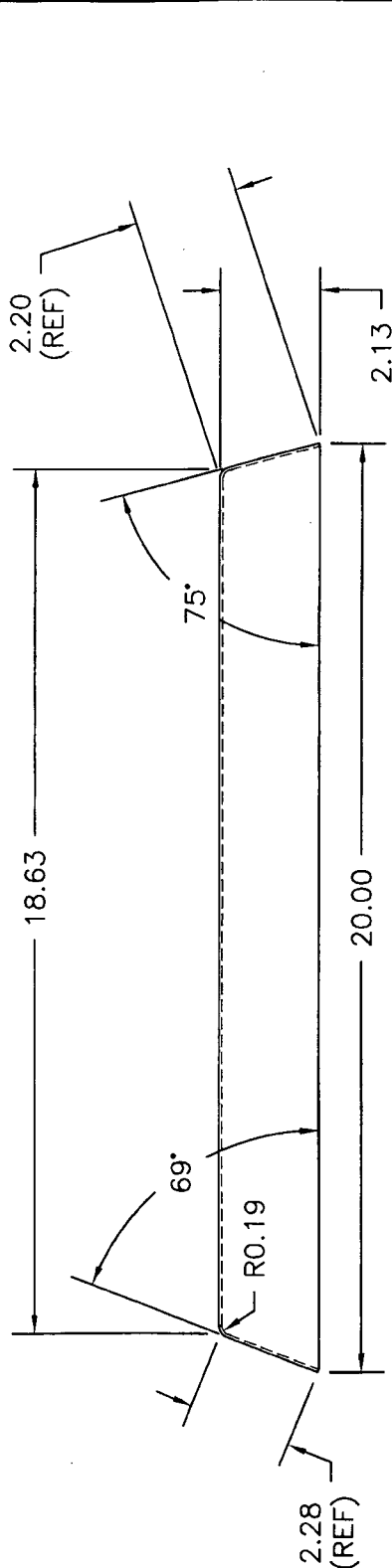
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

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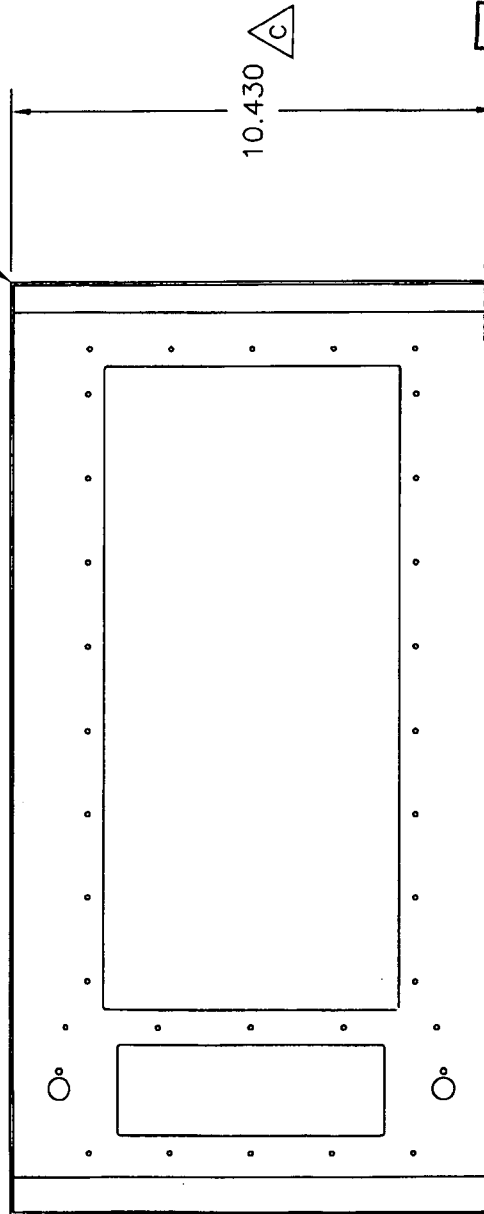
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**DART**

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE  
WELD FLUSH  
(TYP 4 PLACES)



**RELEASED**  
07.06.04 *JS*

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WITHOUT NOTICE  
WORK ORDER  
NO. 51403 *JS*

**D3363-1 BEND DETAIL**  
(MAKE FROM D3363-1F FLAT PATTERN)

**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

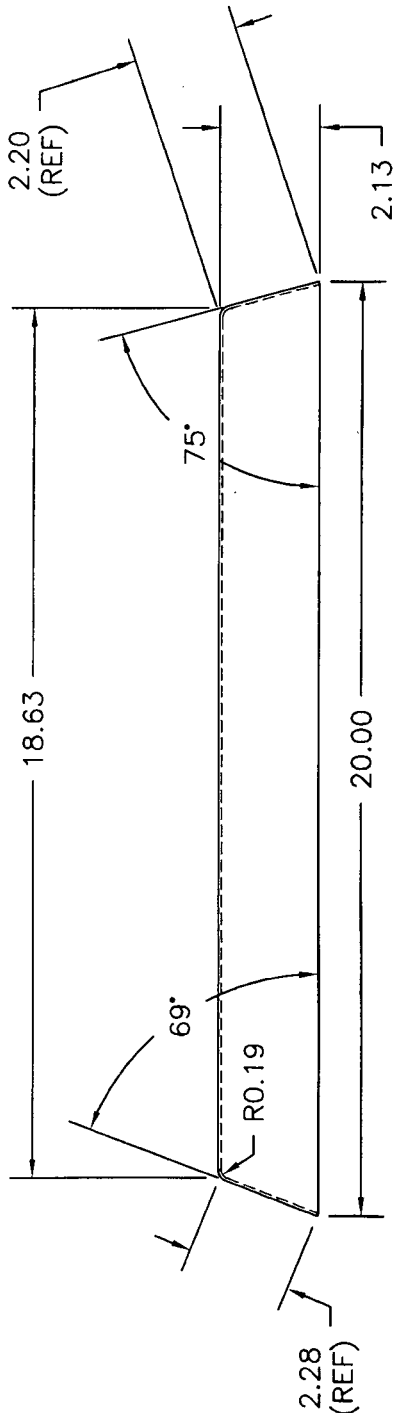
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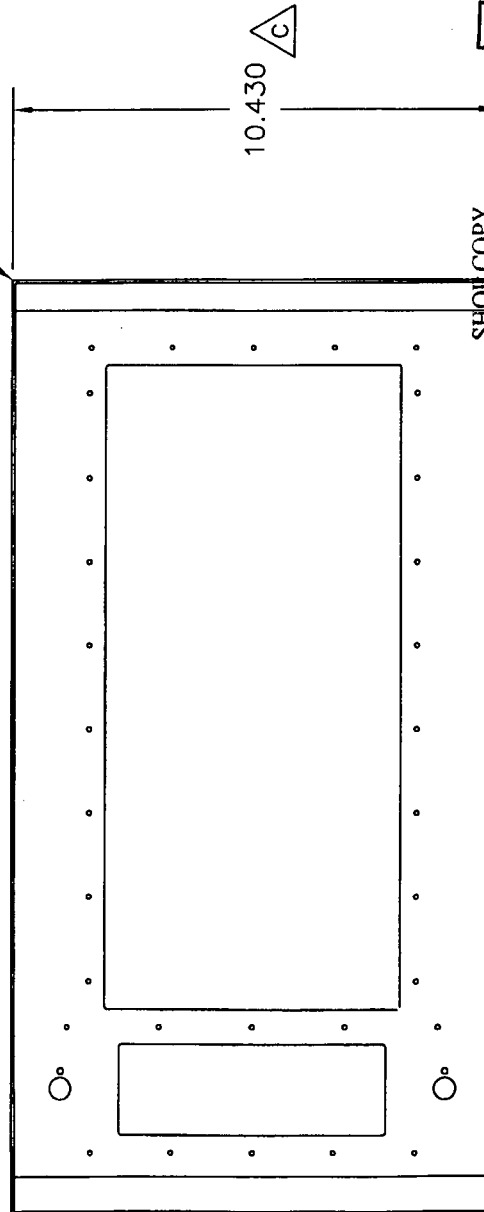


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DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4



GRIND OUTSIDE  
WELD FLUSH  
(TYP 4 PLACES)

**RELEASED**

07.06.04

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WITHOUT NOTICE

WORK ORDER

NO. 51403

**D3363-1 BEND DETAIL**

(MAKE FROM D3363-1F FLAT PATTERN)

**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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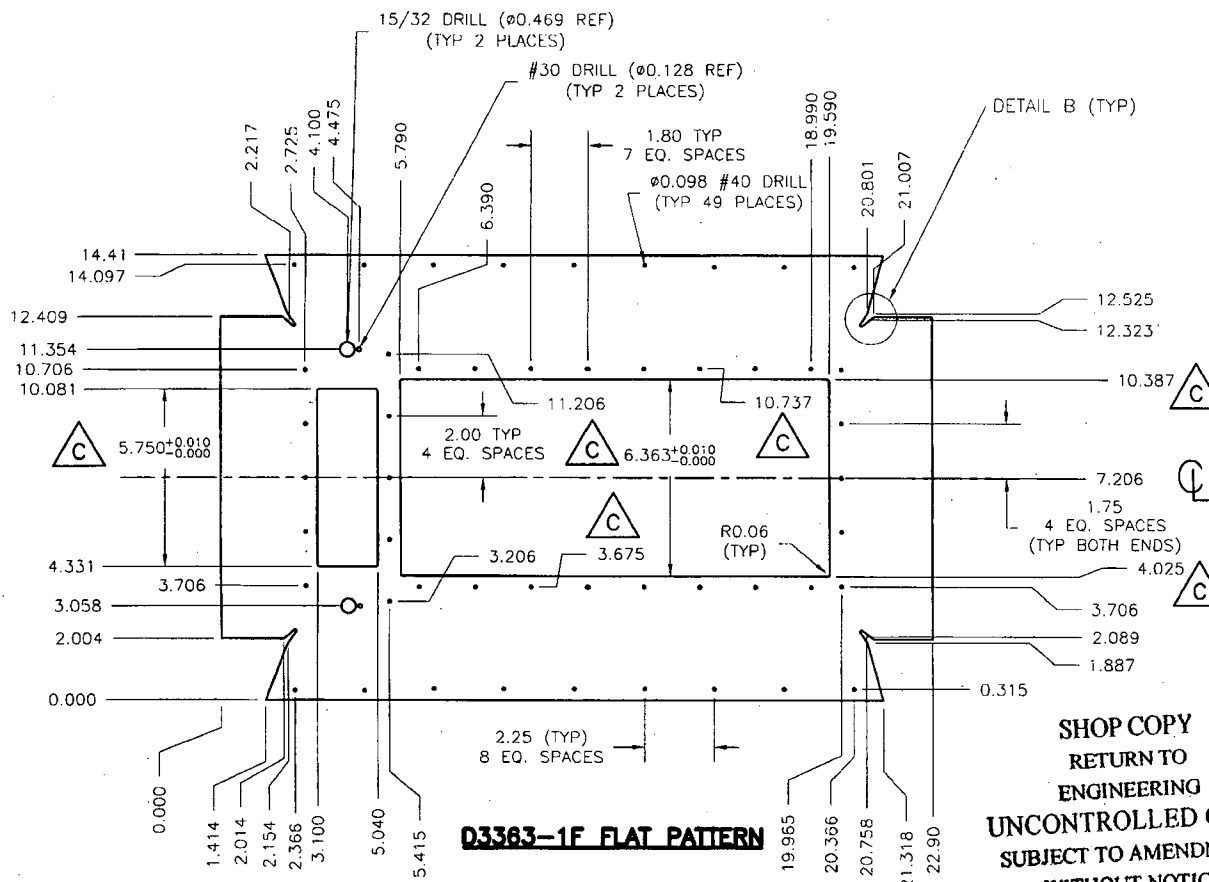
**DART**

DESIGN	BY	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	3	APPROVED	DRAWING NO. D3363
DATE	07.01.26	TITLE	CONSOLE ASSEMBLY
		SCALE	1:6
		SHEET	3 OF 3
		REV.	C

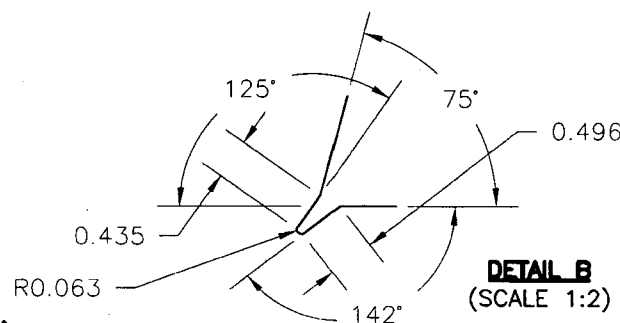
**RELEASED**

07.06.04

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WORK ORDER  
NO. B51403



**D3363-1F FLAT PATTERN**



**DETAIL B**  
(SCALE 1:2)

**D3363-1F CONSOLE (FLAT PATTERN)**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

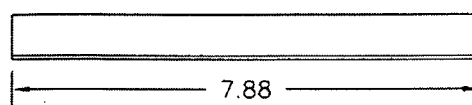


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3360	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE ANGLE	SCALE 1:12
A	04.11.29	NEW ISSUE	

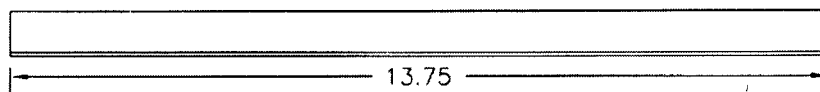
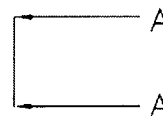
05-03-31 PH

0209109/28

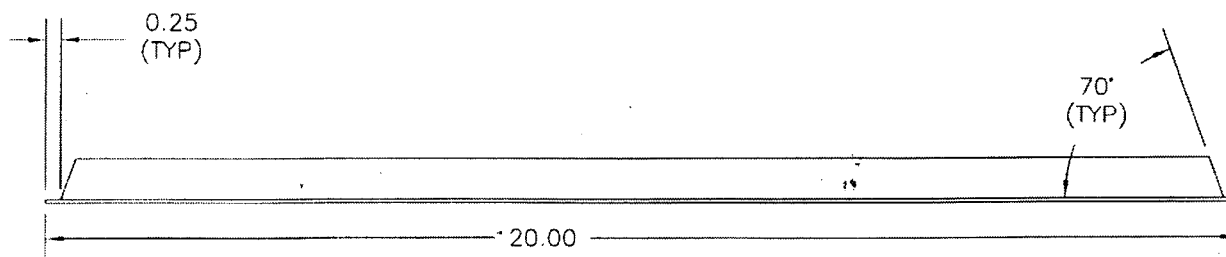
010: 51403



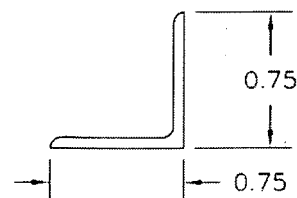
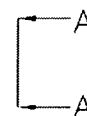
D3360-1  
(SCALE 1:3)



D3360-3  
(SCALE 1:3)



D3360-5  
(SCALE 1:3)



SECTION A-A  
(SCALE 1:1)

D3360-1/-3/-5 ANGLE

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM  
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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#### 4.0 WEIGHT AND BALANCE

The following weight and balance information does not include the installation of any equipment in the D212-722-011 Avionics Riser Console Assembly.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D212-722-011 Avionics Riser Console	2.3 lb 1.1 kg	0 in 0 m	0 lb-in 0 kg-m	37 in 0.9 m	85.1 lb-in 1.0 kg-m

#### 5.0 PARTS LIST

Qty - 011	Part Number	Description
X	D212-722-011	AVIONICS RISER CONSOLE
1	D3363-041	CONSOLE ASSEMBLY
8	PFSC35-38A/	DZUS FASTENERS
REF	D1038-58	FASTENER RAIL
REF	D1038-58B	FASTENER RAIL, BLACK
REF	PR35	DZUS RAIL

REFERENCE ONLY

51403